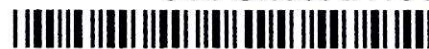




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2893-1
Job Sheet 211011



Part No: D2893-1

Job Qty: 6 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/2/20

Job Tracking No:

Due Date: 7/24/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2893 REV D IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E
Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15
add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C ver:EC DWG /IPP Rev. I 19.10.01 New
issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	6 pcs	7/23/20		2.00	15.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	6 pcs	7/23/20		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S287288



Part: D2893-1

Job No: 211011

Serial No/Batch: S287288

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/11/20

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					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Crosstubes - 2 - B4B	6 pcs	7/24/20	0.00 1.00	Crosstubes - 1 - B4B	DAS
					Crosstubes - 2 - B4B	87 JUL 19 2020
					Crosstubes - 3 - B4B	9-89
					Crosstubes - 4 - B4B	
140	QC 3	6 pcs	7/24/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	JUL 20 2020 DAS
					QC 3 - 40	40
					QC 3 - 19	9-89
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	6 pcs	7/24/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	JUL 20 2020
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180	QC 21 - SA	6 pcs	7/24/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					Broussard
					QC 21 - SA - 9
					QC 21 - SA - 77

JUL 20 2020

DAS

21

9-59

Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and use DT10660 apply 3M Scotch-Weld as per dwg. 5206499

140 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location:) LOCATION : LG050

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	3 pcs (.5 ea)	100-HAAS 4 Axis	5285675

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	3	14	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details: _____ _____ _____			

DART AEROSPACE LTD		Work Order: 211011
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.125	0.160		.143	.144	.144	.144	.144
AB	0.040	0.060		.051	.052	.052	.051	.050
AC	Ø0.260	Ø0.266		.264	.264	.264	.264	.260
AD	Ø0.187	Ø0.143		.189	.189	.189	.189	.187
AE	0.240	0.250		.250	.250	.250	.250	.250
AF	1.347	1.407		1.372	1.372	1.372	1.372	1.370
AG	1.200	1.240		1.210	1.210	1.210	1.210	1.209
AH	0.147	0.167		.160	.165	.158	.160	.151
AI	2.985	3.005		3.000	3.000	2.997	2.998	2.999
AJ	0.400	0.500		.450	.450	.450	.450	.450
AK	4.930	4.990		4.957	4.957	4.958	4.958	4.960
AL	0.125	0.160		.137	.137	.137	.137	.137
AM	R0.053	R0.073		.060	.060	.060	.060	.060
AN	R0.240	R0.260		0.250	0.250	0.250	0.250	0.250
AO	R0.021	R0.041		.031	.031	.031	.031	.031
AP	0.150	0.180		.176	.174	.176	.176	.170
AQ	0.053	0.073		.063	.063	.063	.063	.060
AR	2.302	2.322		2.315	2.315	2.317	2.316	2.317
AS	0.140	0.160		.149	.151	.151	.151	.150
AT	0.040	0.060		.051	.050	.052	.052	.050
Accept/Reject								

Measured by: AK / DAS Date: 20/07/10

Audited by: 20 Date: 20.07.12

Preliminary Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	
E	20.02.10	Dwg Rev and Dimensions updated.	MG <u>mal</u>	<u>DP</u>

DART AEROSPACE LTD		Work Order: 211011
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.125	0.160		0.148				
AB	0.040	0.060		0.050				
AC	Ø0.260	Ø0.266		0.261				
AD	Ø0.187	Ø0.143		0.187				
AE	0.240	0.250		0.250				
AF	1.347	1.407		1.370				
AG	1.200	1.240		1.200				
AH	0.147	0.167		0.150				
AI	2.985	3.005		2.997				
AJ	0.400	0.500		0.490				
AK	4.930	4.990		4.960				
AL	0.125	0.160		0.139				
AM	R0.053	R0.073		0.063				
AN	R0.240	R0.260		0.250				
AO	R0.021	R0.041		0.031				
AP	0.150	0.180		0.170				
AQ	0.053	0.073		0.063				
AR	2.302	2.322		2.317				
AS	0.140	0.160		0.150				
AT	0.040	0.060		0.050				
Accept/Reject								

Measured by: SC-2	Date: 20-07-11
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Audited by: DAS 20 9-89	Date: 20-07-12
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	
E	20.02.10	Dwg Rev and Dimensions updated.	MG <i>mg</i>	DP <i>dp</i>